

Date: Wednesday, 5/16/2007 2:12:53 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT CAP
Job Number : 32427	
Estimate Number : 10312	
P.O. Number : <i>N/A</i>	Part Number : D2646
This Issue : 5/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2646 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 32375	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/5/2007 Qty: 50 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: G 05/08/22 Hole size revised in Step 5 KJ/JLM Est Rev: A Changed Inserts 07-02-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *3794*

1-Spin as per Dwg D2646

2-Material release note required

C207105114 *(50)*

2.0	D2646P	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 AFT-CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

07/06/05 *(50)*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

07.06.06 *(50)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to .250" and sink as per Dwg D2646.

3-Deburr

297 *07.06.11*
07/06/13 *(50)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 17/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ML

07-06-15

(50)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m 104 144

BR/ML
07-06-19

(50)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

07/06/19

(50)

9.0	ALS71032130	Insert
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

INSERT

Batch: *m 103495*

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

FL

07/06/19

(50)

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

En/Don 06-20

(50)

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-14*

HL

07-06-20

(50)

13.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Don 06/02

(50)

Job Completion



U 07-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

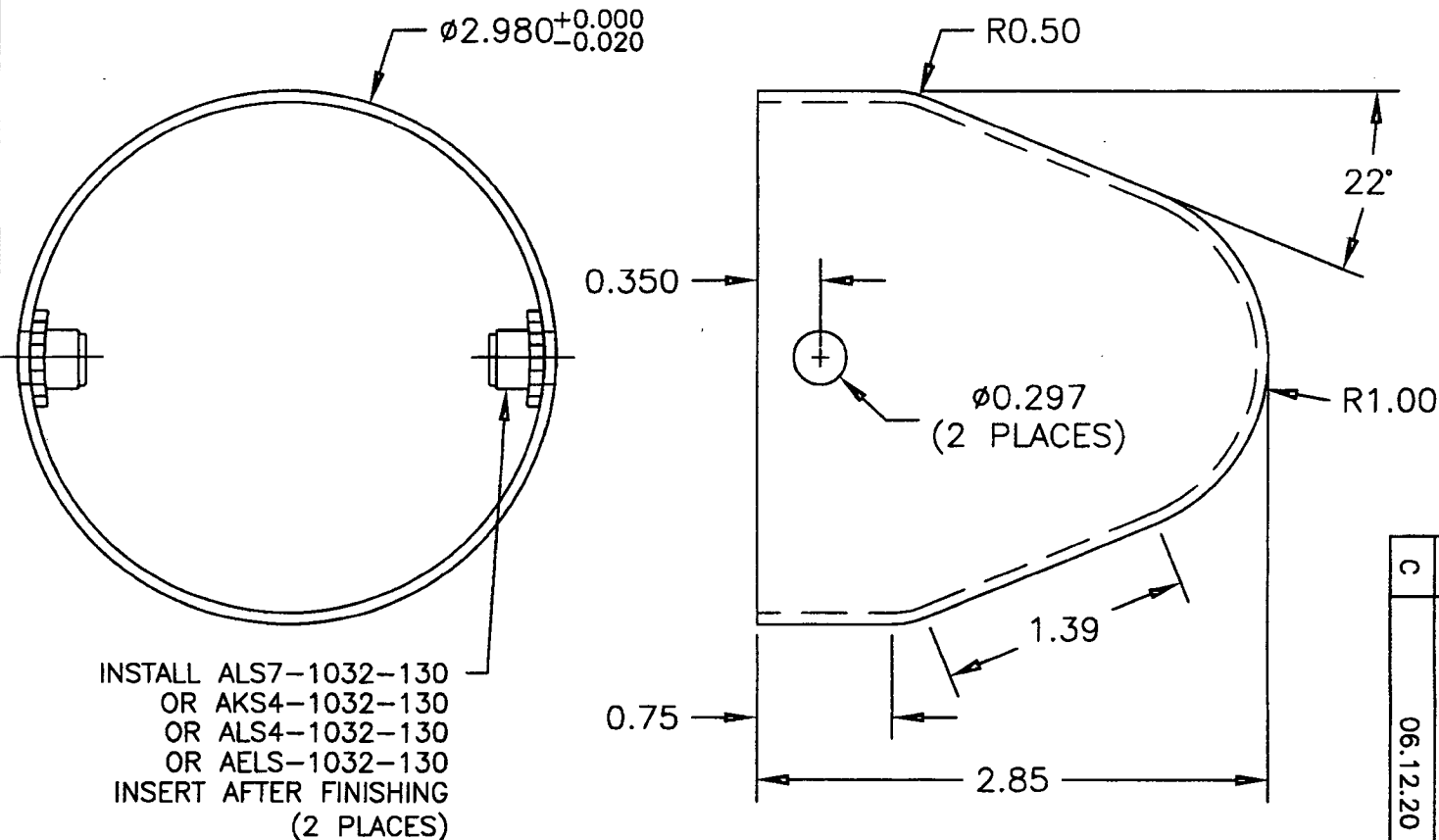
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DS	DRAWN BY	GH	DART AEROSPACE USA, INC.
CHECKED	GH	APPROVED	GH	DRAWING NO. D2646
DATE	06.12.20	TITLE	AFT CAP	REV. C
A	97.03.25	NEW ISSUE		SHEET 1 OF 1
B	05.04.01	CHANGE TO CLOSED INSERTS		SCALE 1:1
C	06.12.20	CHANGE TO OPEN ENDED INSERTS		



INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-O 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

07.02.12

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W/O 32427

Cde7105116



1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO

COPPER & BRASS SALBS INC
22355 WEST BLEVEN MILK ROAD
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS SALES INC
6555 E. DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9,760
PAGE 1 OF 1

ORDER NO	LB4176	PO NO	C99792			MILL FINISH
ITEM NO	1	PART NO	050393-8			NOM ANODIZE QUALITY
ALLOY	1100	TEMPER	O	FORM	COIL	OUT: STANDARD MILL FINISH
GAUGE	06300	WIDTH	48.0000	LENGTH	0.0000	IN: STANDARD MILL FINISH
						NOT EMBOSSED

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 O, AMS 400TH 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

Handwritten signatures and initials:
HAW
Henry @ SHR
C/O
Sore @
LTS

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JEFF FREEDY, LAB SUPERVISOR



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating



6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: June 4/07

Customer: Dart Aerospace

Packing Slip: 31273

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By:
B32375	16	1A61100	N/A	✓	
B32427	50	1A61100	N/A	✓	

Notes:

Material Certification Attached: Yes.

